


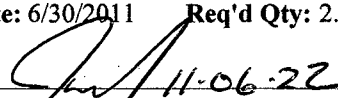




# Work Order ID 71091


Wednesday, June 22, 2011 11:19:06 AM


Page 1

Item ID:	D4403-2	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Fwd Bracket, RH					
Start Date:	6/20/2011	Start Qty:	2.00	Cust Item ID:		
Required Date:	6/30/2011	Req'd Qty:	2.00	Customer:		
Reference:	 11-06-22					
Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start
	QC:	Date:	SPC (Y/N):	Date:		Stop
						
						

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4403	A

100	Cut blanks as per folio	0.00							
									
Bandsaw	Memo	0.00		mk 11/06/23		2	1		
Jeaspa Bandsaw	CUT BLANK AT 7.625"								

110		0.00							
									
HAAS 1	Memo	0.00		mk 11/06/24		2	1		
HAAS CNC vertical machine #1	MACHINE AS PER DWG & FOLIO FB058								
	FOLIO REV: AA								
	DWG REV: A								

DEBURR

**Work Order ID 71091**

Wednesday, June 22, 2011 11:19:06 AM

Page 2

Item ID: D4403-2

Accept

Setup Start

Revision ID:

Stop

Item Name: Fwd Bracket, RH

Start Date: 6/20/2011 Start Qty: 2.00

Cust Item ID:

Required Date: 6/30/2011 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

OK 11/06/24

2

Ø

Quality Control

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

DFS 11/06/24

2

Ø

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Le 11-06-24

2

Ø

Hand Finishing

**Work Order ID 71091**

Wednesday, June 22, 2011 11:19:06 AM

Page 3

Item ID: D4403-2

Accept

Revision ID:

Item Name: Fwd Bracket, RH

Start Date: 6/20/2011 Start Qty: 2.00

Required Date: 6/30/2011 Req'd Qty: 2.00

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

160

Identify as per dwg & Stock Location: ERA

0.00



Packaging

Memo

0.00

Packaging

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

# Picklist Print

Page 1

Wednesday, June 22, 2011 11:19:00 AM

Work Order ID: 71091



Parent Item: D4403-2



Parent Item Name: Fwd Bracket, RH

Start Date: 6/20/2011

Required Date: 6/30/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 11/06/15 JFS VERIFY BY:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M7075T73B01.250X03. 000		Purchased			No	100	f	9.6820	0.64	1.347368			



7075-T73 BAR 1.250" X 3.000"

Location

Loc Qty

Loc Code

MAT008

9.682

117942

9.682

1.35 out 11/06/23

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 71091
<b>Description:</b> FWD BRACKET		<b>Part Number:</b> D4403-2
<b>Inspection Dwg:</b> D4403 <b>Rev:</b> A		<b>Page 1 of 1</b>

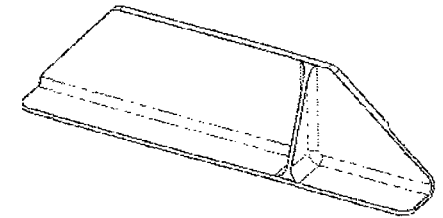
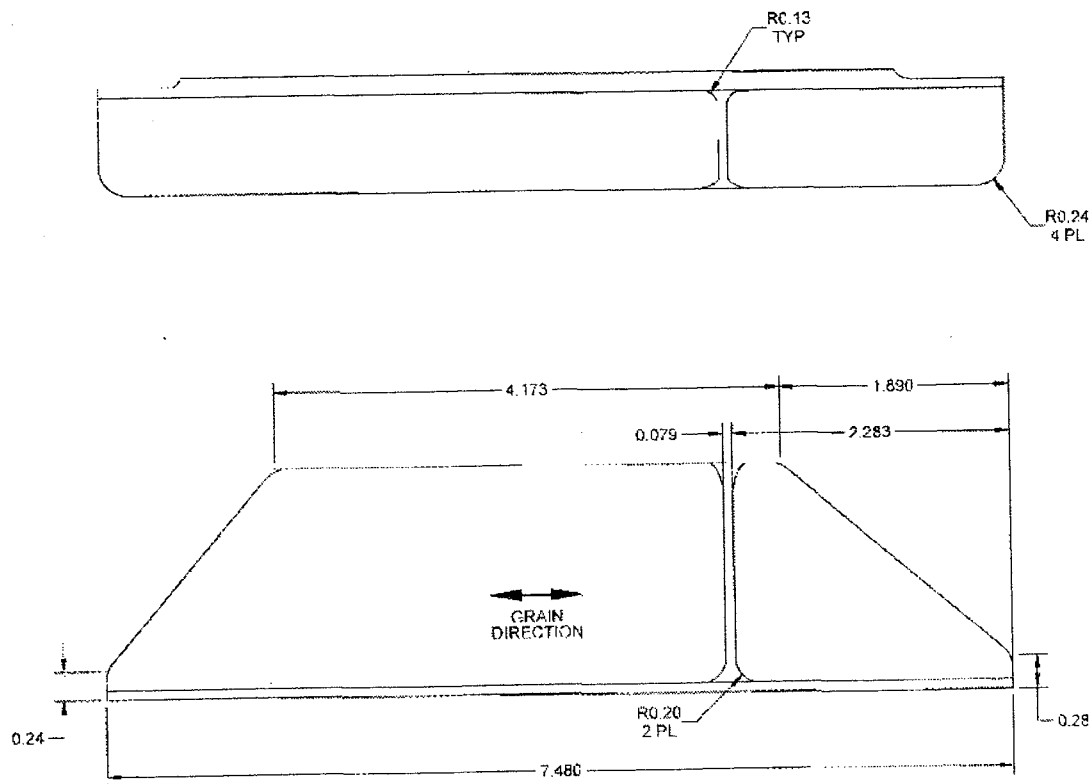
### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R.13	$\pm .030$	R.125	—		R-G	
R.24	$\pm .030$	R.250	—		"	
2.283	$\pm .010$	2.281	—		Vern	ML-7
.079	$\pm .010$	.080	—		"	"
7.480	$\pm .010$	7.482	—		Vern	LNL-02
.079	$\pm .010$	.075	—		"	ML-7
.079	$\pm .010$	.078	—		"	"
.12 X 45°	$\pm .030$	.122 X 45°	—		"	"
R.13	$\pm .030$	R.130	—		R-G	
1.043	$\pm .010$	1.039	—		Vern	ML-7
1.890	$\pm .010$	1.891	—		"	"
.157	$\pm .010$	.161	—		"	"
.965	$\pm .010$	.963	—		"	"

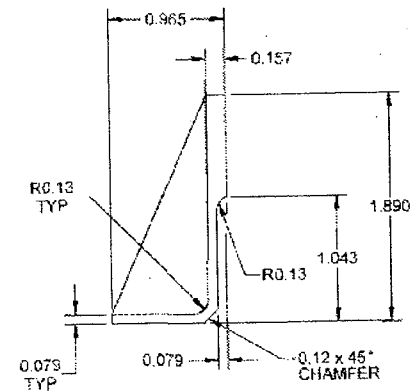
<b>Measured by:</b> <i>SMK</i>	<b>Audited by:</b> <i>DFB</i>	<b>Preliminary Approval:</b>
<b>Date:</b> 11/06/24	<b>Date:</b> 11/06/24	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

*10.04.15*



B71091



**D4403-2 FWD BRACKET, RH**

**RELEASED**  
2011-05-20

**NOTES:**

- 1) MATERIAL: 7075-T7351 ALUMINUM BAR  
AMS-QQ-A-250/12 (AMS 4078)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.18 lbs
- 8) SIMILAR TO AGUSTA P/N 3G2591A07351

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG APPR.	<i>[Signature]</i>	<b>D4403</b>	SHEET 2 OF 8
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>BRACKET</b>	NTS
DATE	11.05.18	COPYRIGHT © 2011 BY DART AEROSPACE LTD	
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